

Date:
User:

Wednesday, 13/05/2009 1:46:35 PM
Julie Dawson

Dart Aerospace Ltd.

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 47946

Estimate Number : 12455

P.O. Number :

This Issue : 13/05/2009

S.O. No. :

Prsht Rev. : NC

First Issue : 1/1

Type : LARGE FAB ASSY

Previous Run : 45187

Written By :

Checked & Approved By :

Comment :

Est Rev:B 05.10.14 Modified step 10 KJ/EC
Est Rev:B 06.07.19 D2946 @ rev.b EC

Drawing Name : AFT MAINTENACE STEP

Part Number : D350591133

Drawing Number : D2946 REV B

Project Number : N/A

Drawing Revision : REV. B

Material :

Due Date : 26/05/2009

Qty:

Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



09/06/24



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-133 CHG002

2.0

D2622120C

Step Extrusion



Comment: Qty.: 0.5250 Each(s)/Unit Total : 2.1000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2622-120C

Extrusion

346910

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

2-Deburr

Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

D2734

Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

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Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2734

End Plate 343535

6.0

D2944

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2944 Support 336407

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Deburr and Bevel ends for welding

2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946

A/R Aluminum Rod M110130
M110972

3-Grind End Cap welds flush

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

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Drawing Name: AFT MAINTENACE STEP

Job Number: 47946

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

A/R AL ROD BATCH: M110130

24-06-23

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

24-06-24

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

24-06-24

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

48

09-06-24

x6

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M111472
x pressure wash

09-06-24

x6

START TIME:

10:00am

OVEN TEMPERATURE:

320°C

FINISH TIME:

10:30am

9/6

09-06-24

x6

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2946 and QSI 005 4.4

9/6/24

UMD

2

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

9/6/24

SP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT MAINTENACE STEP

Job Number: 47946

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN414A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Batch: M110372

9/6/24

SP

27.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 56.0000 Each(s)

Washer

Batch: M111279

9/6/24

SP

28.0

MS21042L4

Nut



SP

Comment: Qty.: 14.0000 Each(s)/Unit Total : 56.0000 Each(s)

Nut

Batch: M110507

9/6/24

SP

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-213

Location:

PPP Rev:

9/6/24

SP

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24

Completion



MF
09-06-24

DART

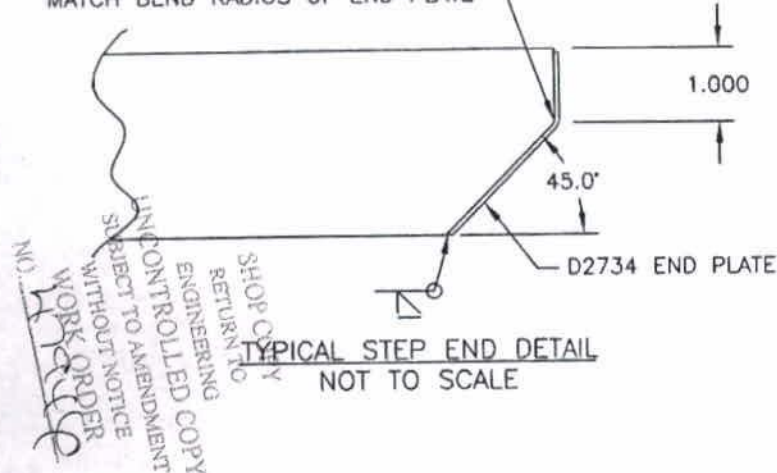
D2946 STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

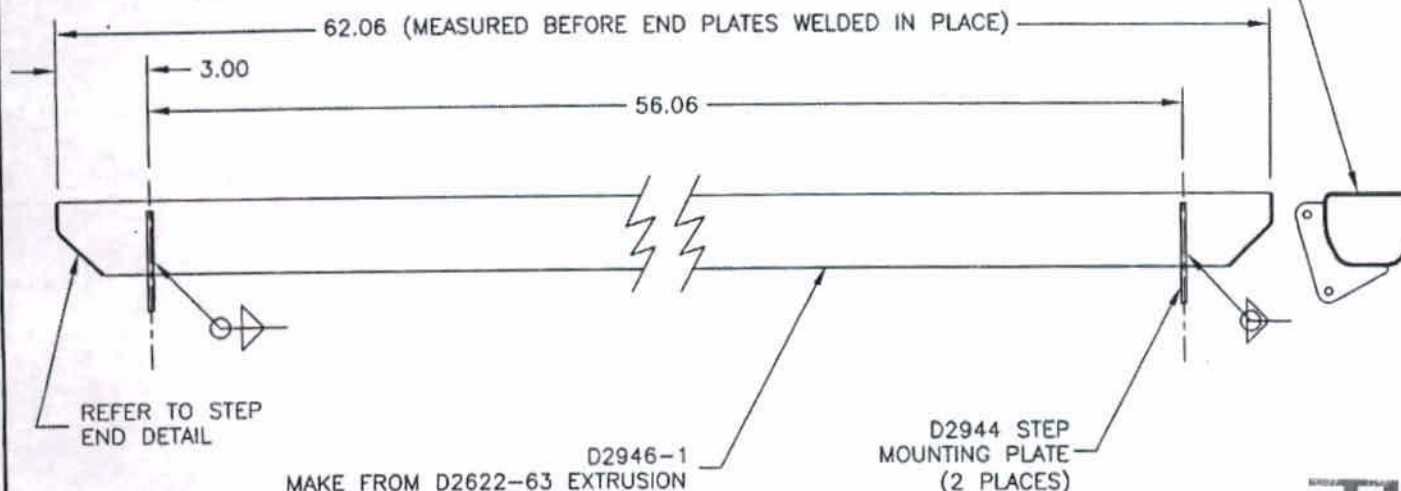
*cut per drawing

NOTE: ALL WELDS SHALL BE
100% VISUALLY
INSPECTED BY A
QUALIFIED INSPECTOR
PER DART QSI 004

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	CP	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D2946
DATE	05.11.14	TITLE	STEP ASSEMBLY	REV. B SHEET 1 OF 1
A	99.12.13	NEW ISSUE		SCALE 1:6
B	05.11.14	UPDATE FINISHING NOTE		

RELEASED
05-11-28